

54532 - Deriv

Split-2

Work Order ID 53030

October 22, 2009 10:05:42 AM

Page 1

Item ID: D3849-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR

Start Date: 21/10/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan: *PI*Date: *9-10-07*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3849

B

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3849

Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

0.00

0.00

AB 9-10-07

(4)

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

AB 9-10-07

Work Order ID 53030
October 22, 2009 10:05:43 AM



Item ID: D3849-041
Revision ID: B
Item Name: FWD WEARPLATE ASSY, STD/FLOOR GEAR
Start Date: 21/10/2009 Start Qty: 4.00
Required Date: 30/10/2009 Req'd Qty: 4.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

27809/10/07

4

0

130



Brake NC

Brake NC

Memo

Form as per dwg using DT8179 & DT8155

0.00

0.00

8809/11/2

4

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

4

10/11/11

Work Order ID 53030

October 22, 2009 10:05:43 AM



Page 3

Item ID: D3849-041
 Revision ID: B
 Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR
 Start Date: 21/10/2009 Start Qty: 4.00
 Required Date: 30/10/2009 Req'd Qty: 4.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150



Large Fab

Large Fab

Memo

0.00

0.00

1- On D3901-1 bar, fill cut outs with hardcoat welding rod as per dwg D3849
 2059 B Hardcoat Welding Rod
 BATCH#: M112963

2- Weld D3901-1 bar to wearplate by positioning holes together as per dwg D3849
 304 S.S. Welding Rod
 BATCH #: M102421

EL

9-12-11

(X3)

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds ✓ 0.00

Memo

0.00

(3x)

6/07/14/18

Work Order ID 53030

October 22, 2009 10:05:43 AM



Page 4

Item ID: D3849-041
 Revision ID: B
 Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR
 Start Date: 21/10/2009 Start Qty: 4.00
 Required Date: 30/10/2009 Req'd Qty: 4.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) 502/12/18			(3)			
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 8:30 OVEN TEMPERATURE: 320 FINISH TIME: 9:00	0.00 0.00	16/09-12-21			(3)			
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	21/09-12-21			(13) 0			

Work Order ID 53030

October 22, 2009 10:05:43 AM



Page 5

Item ID: D3849-041

Accept



Setup Start



Revision ID: B

Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR

Stop



Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200



Small Fab

Small Fab

Memo

0.00

0.00

1- Bond D3848-1 gasket to inner surface of wearplate using a thin layer of 3m
1300/1300L scotch grip adhesive as per dwg
BATCH: 4113174

9/509/12/22 (3)

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

3

9/512/22

220



Packaging

Packaging

Identify as per dwg & Stock Location: 179

0.00

Memo

0.00

9/12/29 34 (34)

Work Order ID 53030

October 22, 2009 10:05:43 AM



Page 6

Item ID: D3849-041

Accept



Setup Start



Revision ID: B

Item Name: FWD WEARPLATE ASSY, STD/FLOAR GEAR

Stop



Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-01-05

MF
09-12-29

Picklist Print

Page 1

October 22, 2009 10:05:47 AM

Work Order ID: 53030



Parent Item: D3849-041RevB



Parent Item Name: FWD WEARPLATE ASSY, STD/FLOOR GEAR

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3848-1RevB

Manufactured No

Each

12.0000

4.0000



GASKET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST181

12

52530

12

D3901-1RevB

Manufactured No

Each

4.0000

4.0000



Bar

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

4

51841

4

53481 (23) sf

M304S18GA

Purchased

No

197.0169

10.3158



304/316 .050 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

197.0169053

108156

0.98526316

111743

23.7174

112178

44.3142421

112885

128

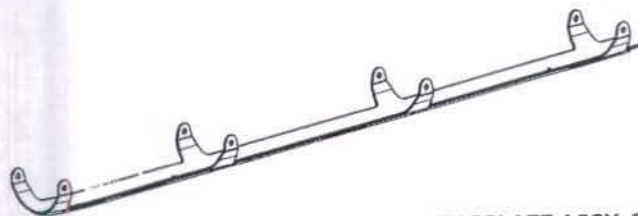
Ep09/12/22

3

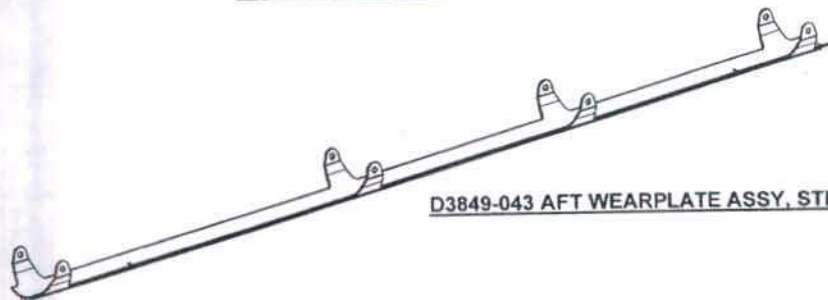
EL 9-12-17

B940-27

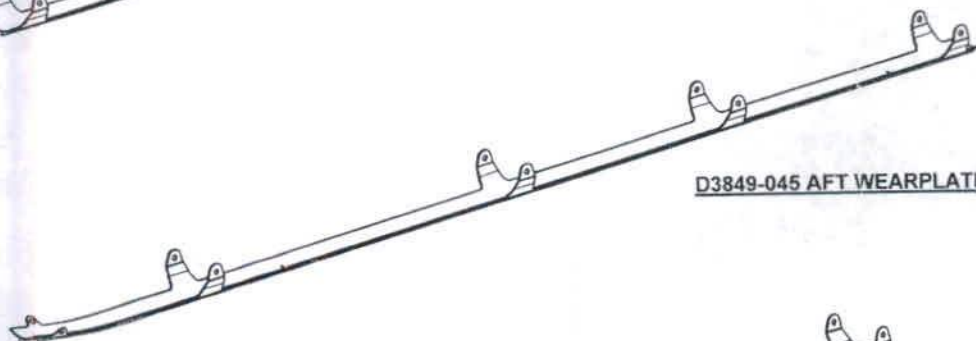
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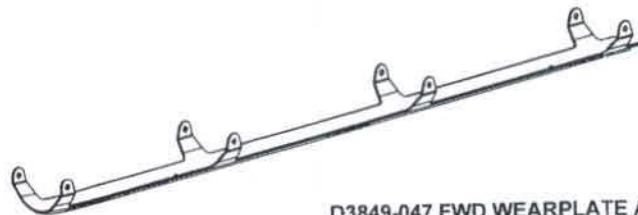
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



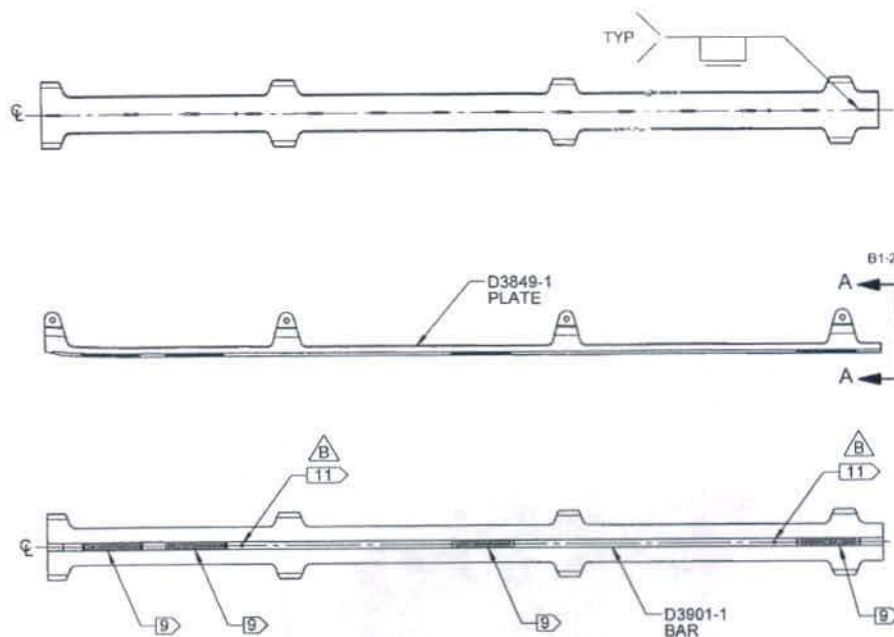
D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1			1	D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
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WORK ORDER
NO. 33030
P/O 020-27

RELEASED
8/6/15/MB

B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F1-3F1-5F (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-71-7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 66.87 WAS 67.36 (ZN B4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	ED	D3849	SHEET 1 OF 10
APPROVED	AW	TITLE	SCALE
DE APPR.	W	WEARPLATE ASSY	NTS
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D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-041" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-041 = 4.24 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-1 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-1 PLATE TO D3901-1 BAR

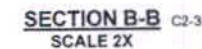
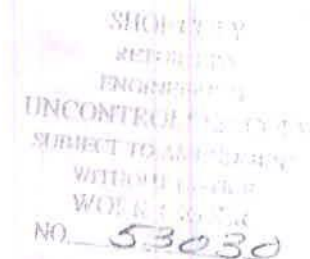
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WORK ORDER NO. 53030



SECTION A-A C3-2
SCALE 2X

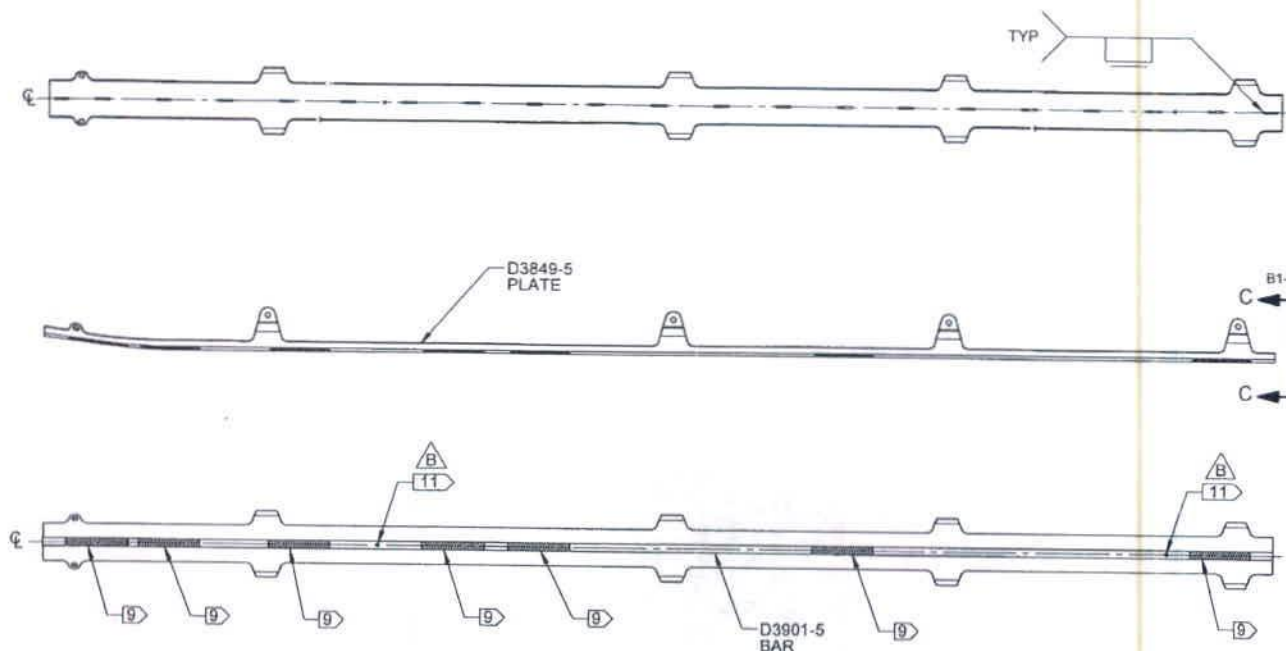
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09/07/12

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9/27/15

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MFG. APPR.	<i>ES</i>	D3849	SHEET 3 OF 10
APPROVED	<i>IN</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	WEARPLATE ASSY	NTS
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D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL $\phi 0.188$ HOLES FROM D3849-5 PLATE TO D3901-5 BAR

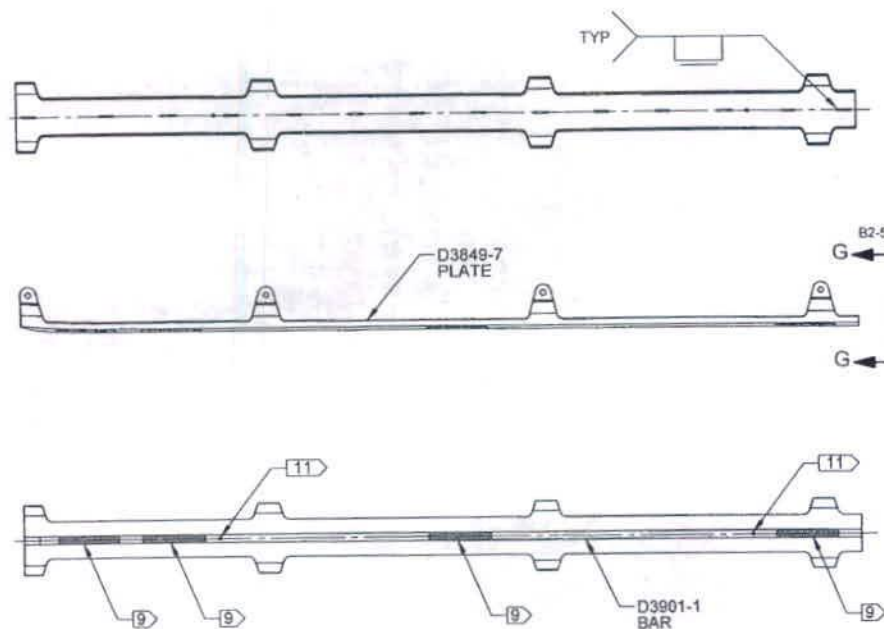
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SECTION C-C C2-4
SCALE 2X

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09/15/14

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MFG. APPR.	RF	D3849	SHEET 4 OF 10
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D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR ⚠

SHOPLIST
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NO. 53030



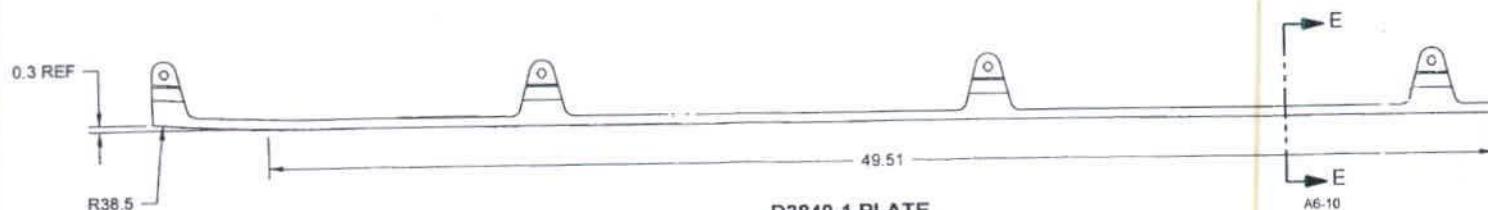
SECTION G-G C3-5
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-047 = 4.26 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-7 PLATE TO D3901-1 BAR

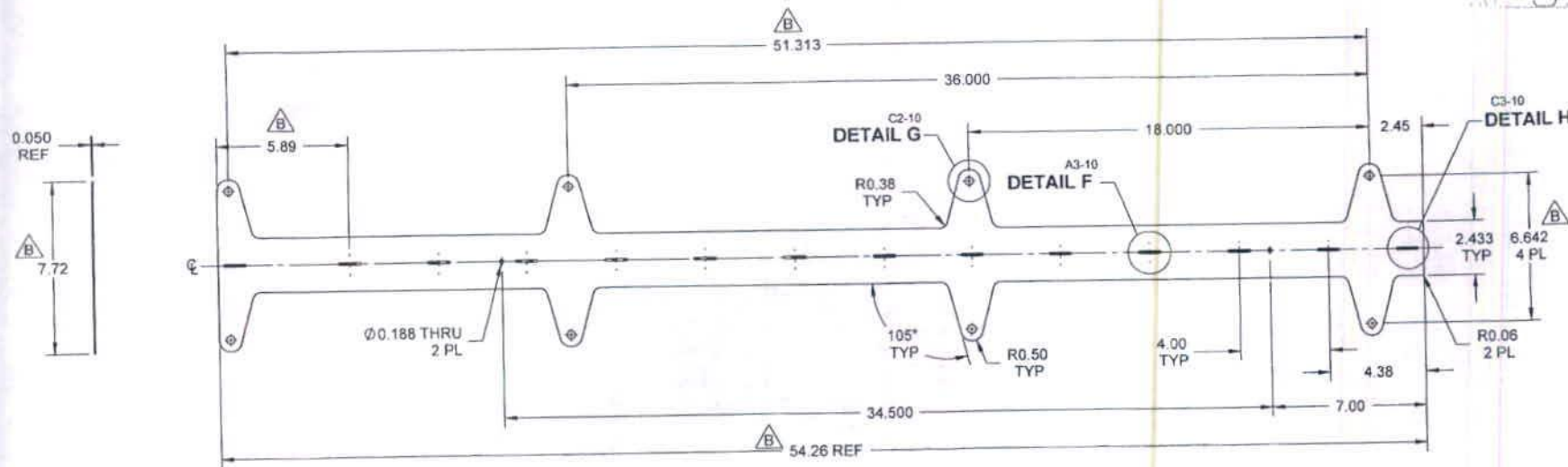
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09/07/15 MFB

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MFG. APPR.	RF	D3849	SHEET 5 OF 10
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D3849-1 PLATE
(MAKE FROM D3849-1F)

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NO. 53030



D3849-1F FLAT PATTERN

RELEASED
09/07/15

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.33 lbs

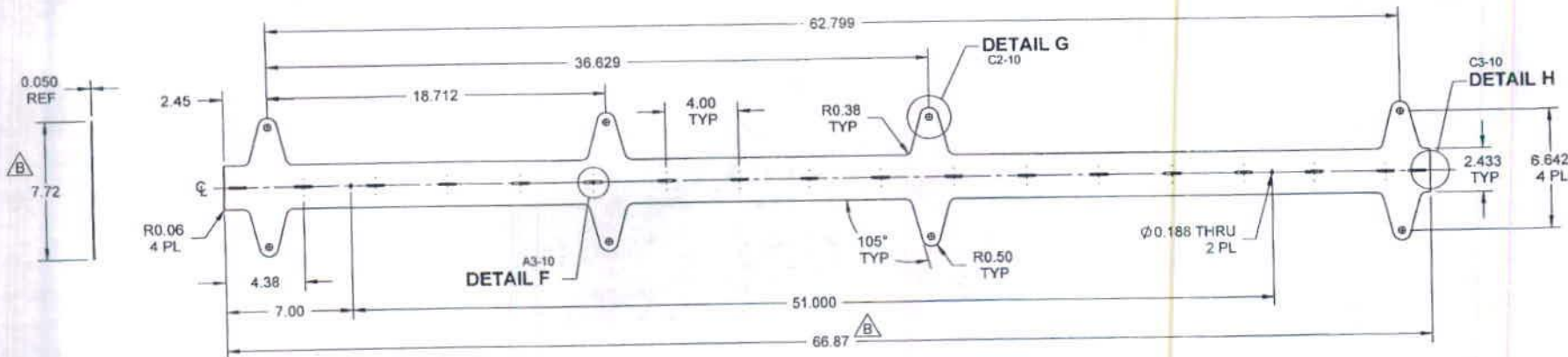
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D3849-3 PLATE
(MAKE FROM D3849-3F)

E
E
A6-10

UNION...
STREET...
WITH...
WORK...
NO. 53030

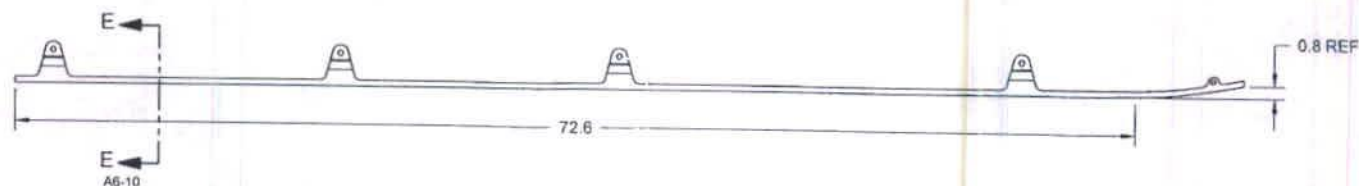


D3849-3F FLAT PATTERN

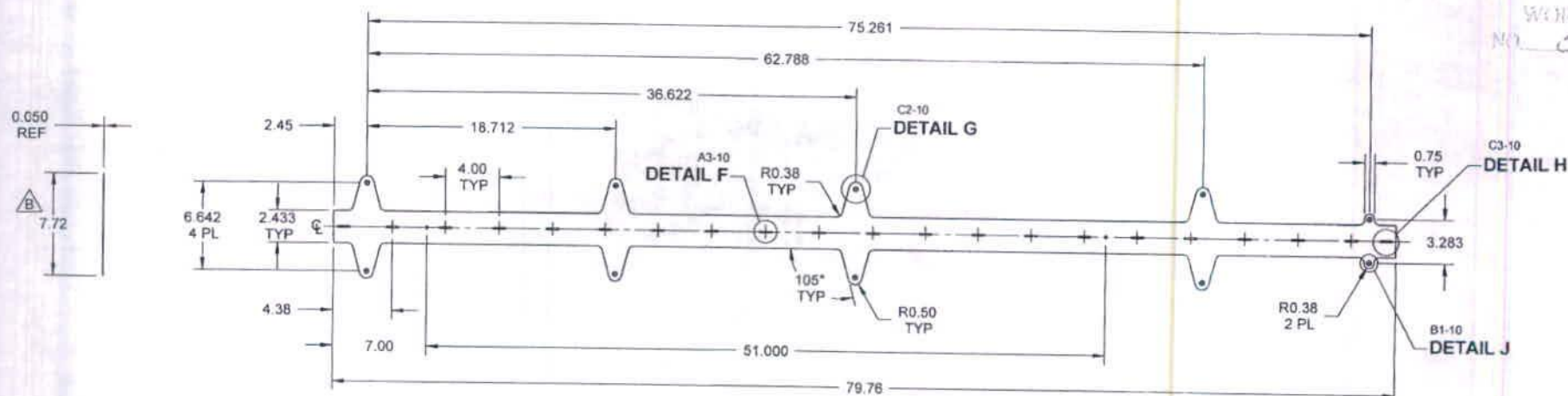
RELEASED
9/16/15

- NOTES:**
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 2.82 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 7 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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D3849-5 PLATE
(MAKE FROM D3849-5F)



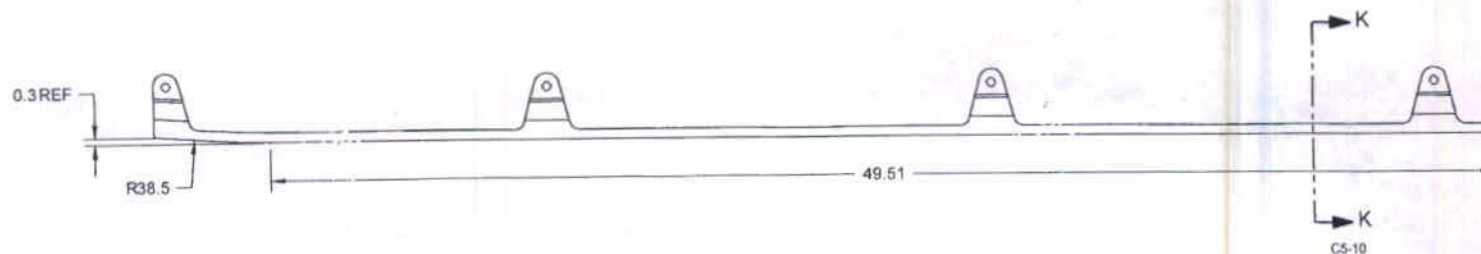
D3849-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.30 lbs

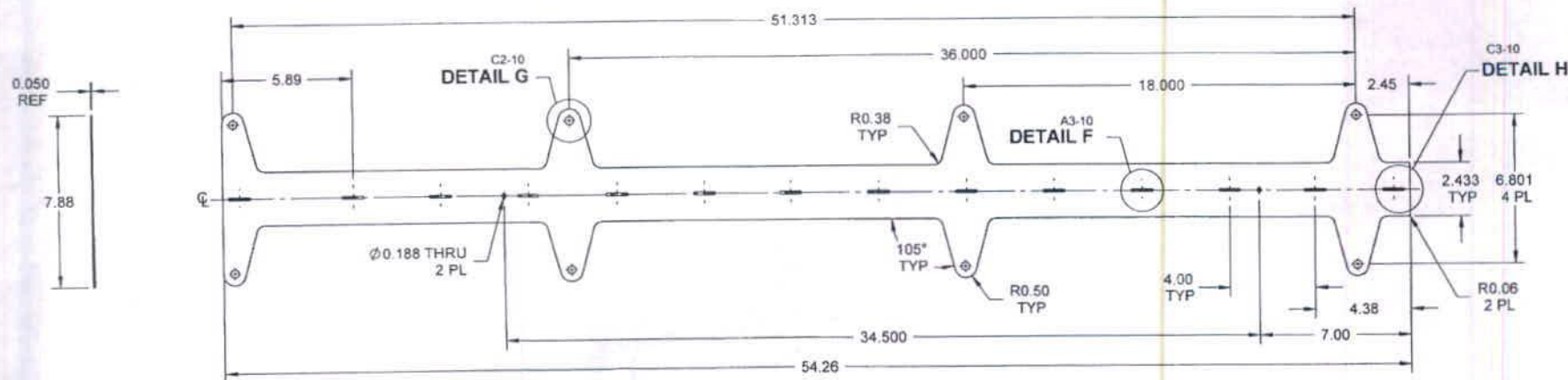
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9/10/15

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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 8 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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D3849-7 PLATE
(MAKE FROM D3849-7F)

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SUBJECT TO A CHANGE
WITHOUT NOTICE
WORK ORDER NO. 53030



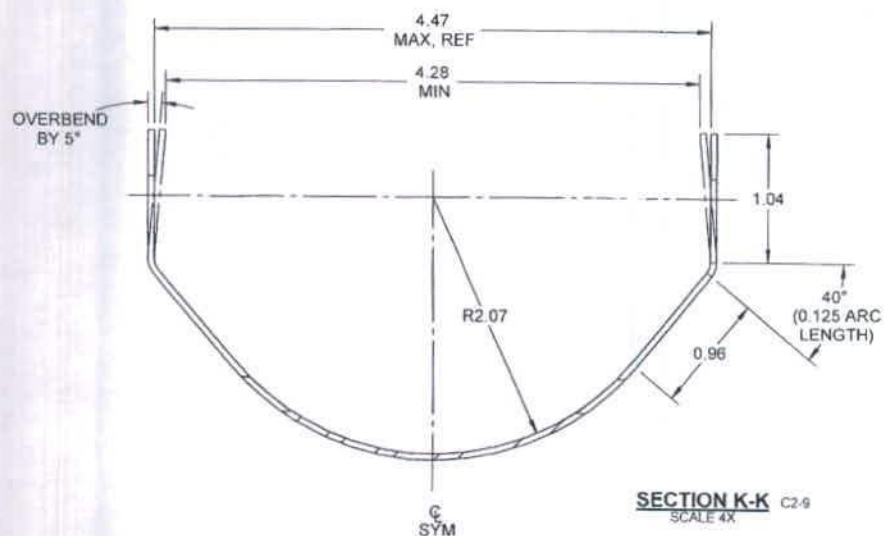
D3849-7F FLAT PATTERN

RELEASED
09/07/15

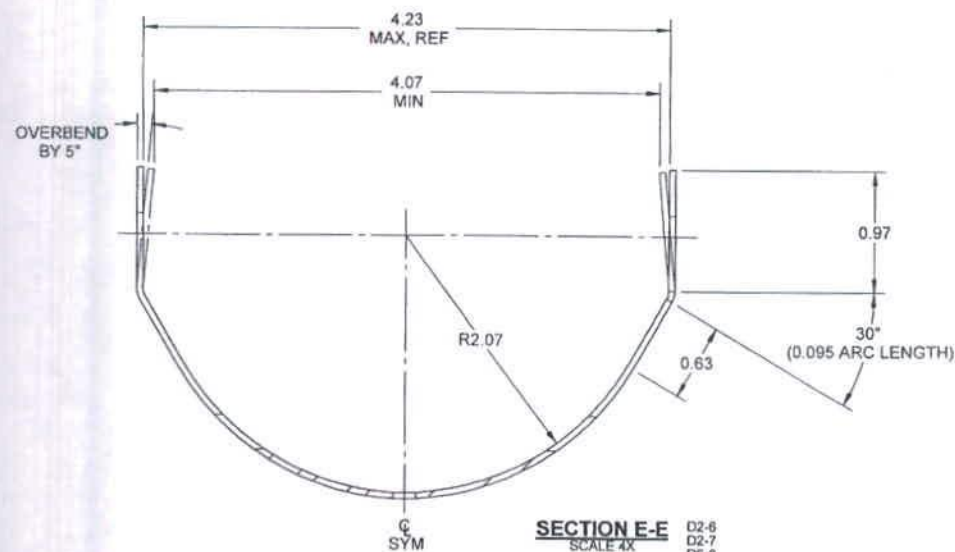
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.34 lbs

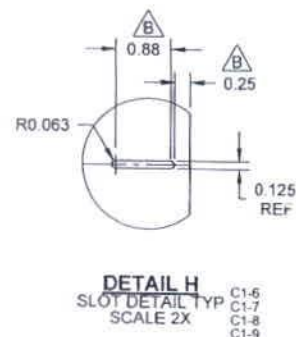
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 9 OF 10
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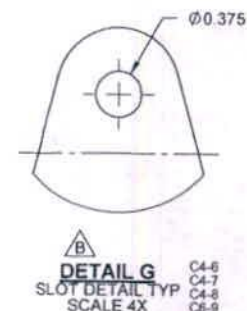
SECTION K-K C2-9
SCALE 4X



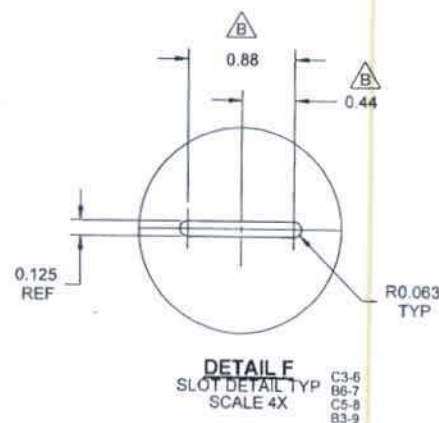
SECTION E-E D2-6
D2-7
D6-8
SCALE 4X



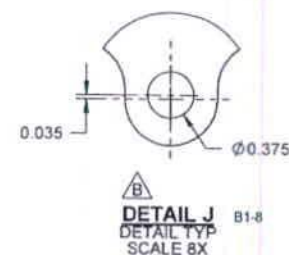
DETAIL H
SLOT DETAIL TYP
SCALE 2X



DETAIL G
SLOT DETAIL TYP
SCALE 4X



DETAIL F
SLOT DETAIL TYP
SCALE 4X



DETAIL J
DETAIL TYP
SCALE 8X

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DART AEROSPACE LTD		Work Order:	53030
Description: Wearplate		Part Number:	D3849-1
Inspection Dwg: D3849	Rev: B		041 Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.190	*			
Ø0.375	+0.006/-0.001	0.379	✓			
5.89	+/-0.030	5.891	✓			
18.000	+/-0.010	18.000	x			
36.000	+/-0.010	36.000	x			
51.313	+/-0.010	51.313	✓			
2.45	+/-0.030	2.45	✓			
2.433	+/-0.010	2.433	x			
6.642	+/-0.010	6.640	✓			
4.38	+/-0.030	4.38	x			
7.00	+/-0.030	7.00	x			
4.00	+/-0.030	3.990	✓			
34.500	+/-0.010	34.500	x			
54.26	+/-0.030	54.250	✓			
7.72	+/-0.030	7.717	x			
0.050	+/-0.010	0.048	x			

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	9-10-21	Date:	09/10/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.01	New Issue	KJ	

